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	er ID 61105 6, 2010 9:50:27 AM									Page 1
Item ID: Revision ID:	D205-634-041	F	Accept				s	etup Star	t	
Item Name:	Replacement Skidtube							Sto	р	
Start Date: Required Date: Reference:	8/6/2010 Start Qty: 1.00 8/19/2010 Req'd Qty: 1.00			Cust Item I Customer:	D:					
Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	un Stai Sto		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D2580	Rev D	•								•
100	DOCUMENT CONTROL		0.00						1 10-5	7-00

110

CNC Bend 1

Document Control

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

W/O:			ORK ORDER C	HANGES					* 1		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Work Ord Friday, August (j i ii ii 1000 oo ii 1100							Page 2
Item ID: Revision ID:	D205-634-0	041		Accept						Start		
Item Name:	Replacement	Skidtube							S	top		
Start Date: Required Date: Reference:	8/6/2010 : 8/19/2010	Start Qty: 1.00 Req'd Qty: 1.00	1818 130 186 1818 116 181		Cust Item I Customer:	D:					,	
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Skidtubes Skidtubes		Memo 1 - Deburr e	nds	0.00				7		<u> </u>	ØE.	10/08
		2- C'sink ho	les as per dwg without cur	tting fluid					i. Že			
		3- Prepare to	ube for welding, remove a	lodine as required.			·					
		4- Scribe ba	tch number insied aft end	of tube.			-					•

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

V/O:			'	NGES		*			
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	Resolution:		Disposition:	QA: N/C Closed:	Date: _	

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	, N, ,		Description of NC		Corrective Action Section B.		Verification	Approval	Approval
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Work Order ID 61105

Friday, August 06, 2010 9:50:27 AM



Item	ID.

D205-634-041

Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 8/19/2010

Start Qty: 1.00 8/6/2010

Req'd Qty: 1.00



Accept



Setup Start



A. C. Start B. C. C.



Reference:

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QC:

Process Plan:

Operation

Description

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

140

Skidtubes Skidtubes

Set Up/ **Run Hours**

0.00

Tool ID

Cust Item ID:

Customer:

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Insp. Number Stamp

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/R□□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE10/08/31

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W/O:			V	ORK ORDER CHANG	ES					,
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Work Order ID 61105

Friday, August 06, 2010 9:50:27 AM



Page 4

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/6/2010

Start Qty: 1.00

Required Date: 8/19/2010

Req'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling: SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

150

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept **Qty**

Reject Oty

Reject Insp. Number Stamp

160

Quality Control

QC5- Inspect part completeness to step on W/O

170

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Memo

0.00

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 Bl 10 9-1

0.00

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Friday, August 06, 2010 9:50:27 AM

Item ID: 🤫

D205-634-041

Accept

Setup Start



Revision ID:

Replacement Skidtube Item Name:

Start Date:

8/6/2010

Start Oty: 1.00

Required Date: 8/19/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start Stop

Stop

QC:

Date:

SPC (Y/N):

Date:_

Reject

Reject Insp.

Sequence ID/ **Work Center ID**

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per OS1005 4.3-Alum

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Qty

Number

Stamp

START TIME:

OVEN TEMPERATURE: FINISH TIME:

Memo

QC3- Inspect Part Finish

0.00 => M 10/09/08

QC Quality Control

Memo

0.00

190

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Friday, August 06, 2010 9:50:27 AM



Page 6

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

8/6/2010

QC:

Start Qty: 1.00

Required Date: 8/19/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Rei	er	en	ce:

Approvals:

Process Plan:

Operation

Description

Date:_____

Date: Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Start Run

Stop



Sequence ID/ **Work Center ID**

200

HandFinish

Hand Finishing

Set Up/ **Run Hours**

10 (09/08

Accept Qty

Reject Oty

Reject Insp. Number

Stamp

Memo

0.00

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates A/R 000 Sikaflex-291 0M115114000

Sikaflex expire date: 11/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

Inspect for foreign object per OSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R \square \square Sikaflex-291 \square \triangle \triangle \triangle \triangle \triangle

Sikaflex expire date: 11/10

5-Wing Walk as per Dwg D2580 and OSI 005 4.4

Batch: 11/1 105 02 8

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W/O:			WORK ORDER CHANGES							
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Work Order ID 61105

Friday, August 06, 2010 9:50:27 AM



Page 7

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 8/19/2010

8/6/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: ____

Date:

Date: Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Run Start

Stop

Stop

Sequence ID/

Work Center ID

210

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/

Run Hours

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Tool # Plan Accept Code **Qty**

Reject Oty

Reject Insp. Number Stamp

Memo

0.00

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per OSI 024

220

230

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

PPD 6 0923

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

[c/2/10 C

- 10/09/13 D

Quality Control

W/O:		WORK ORDER C	WORK ORDER CHANGES									
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Friday, August 06, 2010 9:50:31 AM

Work Order ID: 61105

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 8/6/2010

Required Date: 8/19/2010

Page 1

Start Qty: 1.00

Required Oty: 1.00

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Manufactured

No

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	4.0000	1 	1 B 60	95 \$	MB	·· 10-08-1
						_	~ :						•

		<u>Locatio</u>	<u>n</u>	Loc	Oty	Loc Code			
		LG			1			_	
			57028		1				
		ST046			3				
			59856		. 2				
			59913		1				
Manufactured	No			140	Each	84.0000	1	1	

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Step (maching detail)

D2576-3

Location	<u>Lo</u>	c Oty	Loc Code			
LG		84				ac mbobs
46661		36				BE 10/08/26
52215		48				/ 4
	140	Each	327.0000	20	20	,



Location	Loc Qty	Loc Code
LG	327	•
57052	5	
57348	4	
58433	2	
59113	182	
60845	134	

20 BE 10/08/26

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Friday, August 06, 2010 9:50:32 AM

Work Order ID: 61105 Parent Item: D205-634-041 Parent Item Name: Replacement Skidtube **Start Date: 8/6/2010** Required Date: 8/19/2010 Start Qty: 1.00 Required Qty: 1.00 D2855 Manufactured No 200 Each 81.0000 Location Loc Qty Loc Code FP6 56613 ST026 80 50513 50770 28 51539 2 (53791) 49 AN3-5A Purchased No 200 Each 1,542.000 10/09/08 Bolt Location Loc Qty Loc Code ST350 1542 105057 Y2 542 115016 500 115371 500 AN960JD10L NAS1149D0332J Purchased No 200 Each 2,633.000 10/09/08 Washer Location Loc Qty Loc Code

2633

2633

ST348

110985

W/O:			W	ORK ORDER CHANG	ES				•
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Friday, August 06, 2010 9:50:32 AM

Work Order ID: 61105 . 1788 | 1886 | 1881 | 1886 | 1881 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 | 1886 Parent Item: D205-634-041 Parent Item Name: Replacement Skidtube **Required Date: 8/19/2010 Start Date: 8/6/2010** Start Qty: 1.00 Required Qty: 1.00 ALS7-1032-130 Purchased No 200 Each 878.0000 50 10/09/08 Insert Loc Code Location Loc Qty 11114723 X 2 0 FP 861 115079 861 ST282 17 113238 17 AN3C4A Purchased No 200 Each 1,889.000 50 BOLT Location Loc Qty Loc Code ST350 1889 11115438 x50 114108 14 114416 12 114523 2 114941 861 115300 1000 AN960C10L NAS1149C0332 Purchased No 200 Each 29.0000 50 50 10/09/08 washer

> Location Loc Qty Loc Code ST245 29 XSO 107534 29

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W/O:			WC	ORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Friday, August 06, 2010 9:50:32 AM

Work Order ID: 61105 Parent Item: D205-634-041 Parent Item Name: Replacement Skidtube **Start Date: 8/6/2010** Required Date: 8/19/2010 Start Qty: 1.00 Required Qty: 1.00 D3566-13 Manufactured No 200 Each 33.0000 Gasket Location Loc Qty Loc Code FP . 53461 2 FP012 31 59661 23 60209 8 D3566-5 Manufactured No 200 Each 36.0000 Gasket Location Loc Oty Loc Code FP 22 60869 22 FP015 14 59158 14 D3566-1 Manufactured No 200 Each 30.0000 Gasket Location Loc Qty Loc Code FP 13 60857 13 FP015 17 57715 2 1361656 59126 3 60202 12

W/O:		WORK ORDER CHANGES										
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Page 5

Work Order ID: 61105

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11

Wearshoe

Manufactured No 200

Each

8.0000

D3564-13

Wearshoe

Manufactured

Location FP019 (59941

Location

FP17

200 Each

> 31 19 12

> > Each

Loc Qty

31.0000

Loc Code

D3564-9

Manufactured No

Loc Oty 200

Loc Code

Wearshoe

Location FP

FP019

55334

Loc Code

24.0000

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Work Order ID: 61105 D205-634-041 Parent Item: Parent Item Name: Replacement Skidtube **Start Date: 8/6/2010** Required Date: 8/19/2010 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured No 200 Each 27.0000 Wearshoe Location Loc Oty Loc Code FG 34806 FP19 57525 58709 FP-19 24 59157 11 60868 13 D2594-3 Manufactured No 200 Each 379.0000 O-Ring, 205 Skidtube Location Loc Qty Loc Code FP 379 55546 19 58191 12 59358 348 D2594-1 Manufactured No 200 Each 419.0000 09/09 Plug, 205 Skidtube Location Loc Qty Loc Code FP 183 42807 112 55002 71 FP14 236 58434 47 XIG 189

W/O:			WC	RK ORDER CHANGI	ES				• 41
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	R	esolution:	Dispositio	n:	_ QA: N/C Clo	sed:		Date: _	
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DATE	0750	Description of NC		on B	verification		1 Approvai	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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DESIG	H	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED.	APPROVED	DRAWING NO. REV. D
	THE STATE OF THE S	#	D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	02.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

PS10-8-09



QTY -041	QTY -045	Part Number	Description	
X		D2580-041	SKIDTUBE ASSEMBLY	
	Х	D2580-045	SKIDTUBE ASSEMBLY	
1	1	D2500-1-190	EXTRUSION	
1	1	D2576-3	STEP	
20	24	D2579	CROSS BOLT SPACER	
16	16	D2594-1	PLUG	
16	16	D2594-3	O-RING	
1	1	D2596	205 WEB	
1	1	D2855	AFT CAP	
1	1	D3564-5	WEARSHOE	SHOP COPY
1	1	D3564-9	WEARSHOE	RETURN TO
1	1	D3564-11	WEARSHOE	ENGINEERING
1	1	D3564-13	WEARSHOE	UNCONTROLLED COP
2	2	D3566-1	GASKET	SUBJECT TO ANTONIO
1	1	D3566-5	GASKET	SUBJECT TO AMENDMENT
1	1	D3566-13	GASKET	WITHOUT NOTICE WORK ORDER
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT	PS10-8-C
50	50	AN3C4A	BOLT	
2	2	AN3-5A	BOLT	
50	50	AN960C10L	WASHER	
2	2	AN960JD10L	WASHER	·

GENERAL NOTES:

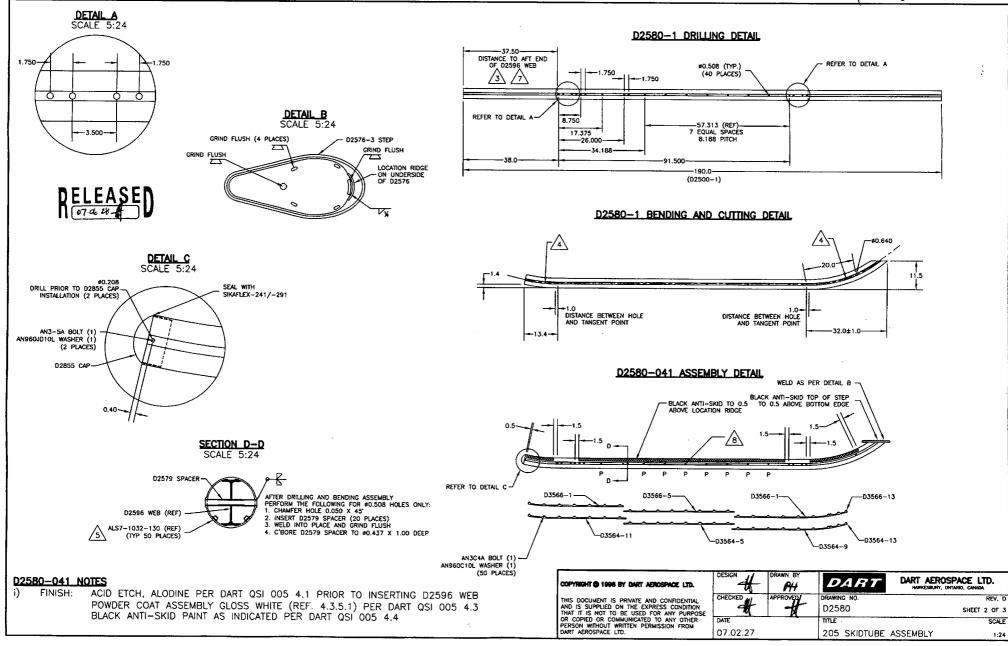
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

SEE NOTES ON PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	\:	Date:	······································
Resolution:						- 10.0	Date:		
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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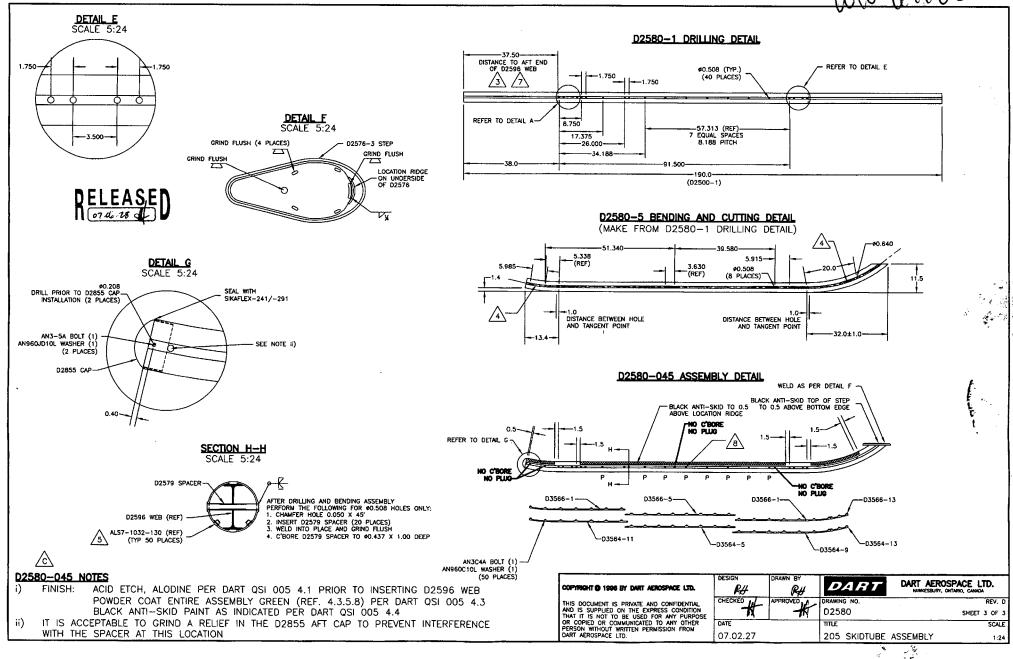


W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	PROCEDURE CHANGE By Date Qty				Approval QC Inspector	
	A							

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
ast "	Resolution:		Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC	Corrective Action Section B			Varification	Ammanual	Ammassal		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	7-75-14-14								
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section A Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Section C Se		

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Category:	NCR: Y	es No DQ	A:	Date: _	*	
	Resolution:		Disposition:	QA: N/0	Closed:		Date: _		

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Annanal	A			
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NOTE: Date & initial all entries

NO. 238

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Ellict	
Job number: 61353	_
Part number: 5205-634-041	
Description: 205 Kid tube	_
Welding Process: Tig[\(\nabla \) Mig[]	_
Base materiel: Aluminium	
Current: AC[DC[]	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Parly Estat	Date of Test Coupon 10.08.25
Weider 1xaning Stroll	Date of Test Coupon <i>10,09.25</i>

The above named individual is qualified in accordance with AWS D17.1.2001 to weld